

Date: Tuesday, 4/4/2006 1:36:01 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : AFT TUBE ASSEMBLY
Job Number : 26533
Estimate Number : 10699
P.O. Number : N/A Part Number : D3391025
This Issue : 4/4/2006 S.O. No. : N/A Drawing Number : D3391 REV D
Prsht Rev. : NC Project Number : N/A
First Issue : N/A Type : LANDING GEAR Drawing Revision : D
Previous Run : 26532 Material : N/A
Due Date : 4/24/2006 Qty: 1 Um: Each
Written By : JA 06.04.04
Checked & Approved By : JA 06.04.04
Comment : Est Rev B 06-02-07 ECN773 dwg rev. D EC
Est Rev:C 06-03-28 Update Manufacturing Instructions JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6014090 ALUMINUM EXTRUSION



Comment: Qty.: 1.0000 f(s)/Unit Total : 1.0000 f(s)

ALUMINUM EXTRUSION

Pick:

Qty Part Number Description Batch

1 D6014-090 Extrusion 24315 (D6014-100) MS 06/04/06

Identify as D3391-3

2.0 MORI SEIKI MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

Turn as per Folio FA599

Rev: AA & Dwg D3391 Rev: D

MS 06/04/07

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MS 06/04/07

4.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS

1-Machine as per Folio FA 599 Rev: AA & Dwg D3391 Rev: D

2-Drill (PILOT HOLE) aft cap holes per Dwg D3391 using DT8803

3-Deburr

MS 06/04/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/4/2006 1:36:02 PM
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Drawing Name: AFT TUBE ASSEMBLY

Job Number: 26533

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ML 06/05/10

1

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

En 06/05/10

7.0

BENDING

BENDING MACHINE



Comment: NC Bender

Form as per Dwg D3391 Using Bend Prog 3391025

DP 06-5-25

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BE 06-5-25

9.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open Aft cap pilot hole to .208" as per Dwg D3391

2-Drill Tube as per D3391 using DT8809 (HOLES MARKED "A" ONLY)

3-Drill and c' sink wearshoe holes as per Dwg D3391 Using DT8878(Mid Tube) & DT8217 Wearplate Jig

4-C'sink holes for float bag (4 holes per side) as per Dwg D3391

5-Deburr

DP 06-5-25

DP 06-5-26

Tools: rill

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BE 06-05-26

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

BT 06-05-29

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Drawing Name: AFT TUBE ASSEMBLY

Job Number: 26533

Part Number: D3391025

Job Number:



Seq. #: Machine Or Operation: Description :

12.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Q.m 06-08-04

(C)

13.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PL 06/08/24

(1)

14.0 AESS10KB366 INSERT



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Insert

Pick:

Qty Part Number Description Batch

14 AESS10KB366 Insert

M101248

15.0 NAS1330C3KB166



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

INSERT

Pick:

Qty Part Number Description Batch

8 NAS1330C3KB166 Insert

M100732

check inv.

16.0 AESS10KB266 INSERT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

INSERT

Pick:

Qty Part Number Description Batch

2 AESS10KB266 Insert

M17905

or NAS1330C3KB266 ✓

17.0 AESS10KB316 INSERT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

INSERT

Pick:

Qty Part Number Description Batch

2 AESS10KB316 Insert

M17905

or NAS1330C3KB316

PL 06/08/25

(1)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Drawing Name: AFT TUBE ASSEMBLY

Job Number: 26533

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Aft Cap

Pick:

Qty	Part Number	Description	Batch
1	D2646	Aft Cap	B28041

19.0

AN3C4A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
2	AN3C4A	Bolt	m101340

20.0

AN960C10L

washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Inventory

Pick:

Qty	Part Number	Description	Batch
2	AN960C10L	Washer	m101340

21.0

NAS1515H3L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Pick:

Qty	Part Number	Description	Batch
2	NAS1515H3L	Washer	m14099

AL 06/08/31 ①

22.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Install inserts as per Dwg D3391

2-Install Aft Cap as per Dwg D3391

A/R Sikaflex-241/-291 M101953

Sikaflex expiry date: 10/06

AL 06/08/31

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DP Date: 06/09/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: AFT TUBE ASSEMBLY

Job Number: 26533

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

MA 06 08 31

(1)

24.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *N/A*

DL

06/08/31

(1)

25.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

QD

06/08/12

Job Completion



U 0609.12

Dart Aerospace Ltd

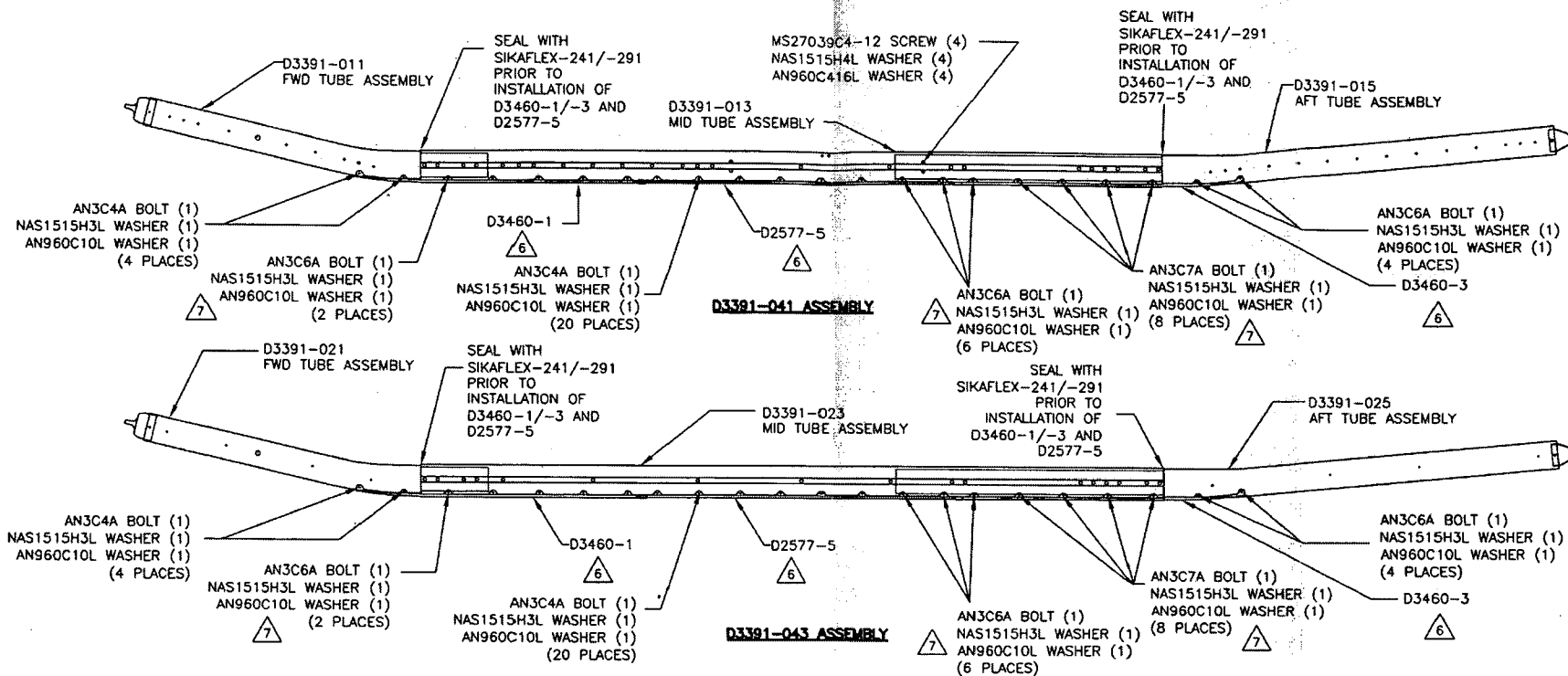
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3391-041/-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY - 041	QTY - 043	PART NUMBER	DESCRIPTION
X	X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
		D3391-043	FLOAT SKIDTUBE ASSEMBLY
1		D3391-011	FWD TUBE ASSEMBLY
1		D3391-013	MID TUBE ASSEMBLY
1		D3391-015	AFT TUBE ASSEMBLY
	1	D3391-021	FWD TUBE ASSEMBLY
	1	D3391-023	MID TUBE ASSEMBLY
	1	D3391-025	AFT TUBE ASSEMBLY
24	24	AN3C4A	BOLT
12	12	AN3C6A	BOLT
8	8	AN3C7A	BOLT
44	44	NAS1515H3L	WASHER
44	44	AN960C10L	WASHER
4	4	MS27039C4-12	SCREW
4	4	NAS1515H4L	WASHER
4	4	AN960C416L	WASHER
1	1	D2577-5	WEARSHOE
1	1	D3460-1	WEARSHOE
1	1	D3460-3	WEARSHOE

GENERAL NOTES

- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL 'E' SIZE HOLES (#0.250-#0.257) FOR WEARSHOE INSERTS.
- C/SINK #0.391/#0.425 x 100" AS APPLICABLE AND INSTALL INSERTS EXCEPT WHERE INDICATED.
- APPLY A LAYER OF SIKAFLEX -241/-291 ADHESIVE BETWEEN THE BOTTOM OF THE SKIDTUBE ASSEMBLY AND THE WEARPLATES
- DO NOT TORQUE, HAND TIGHTEN ONLY

△

RELEASED

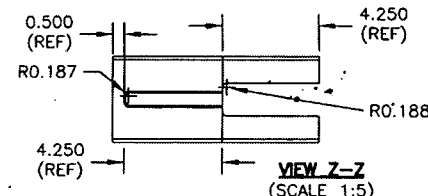
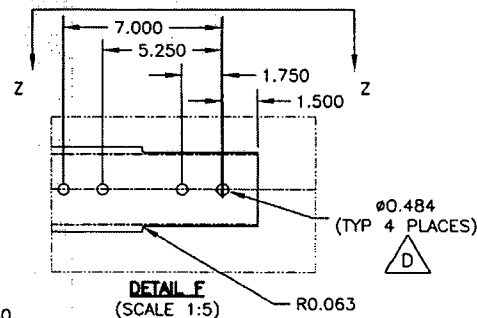
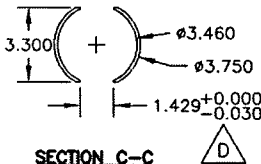
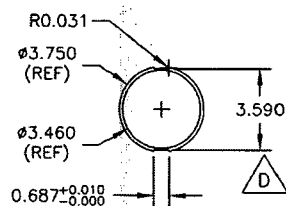
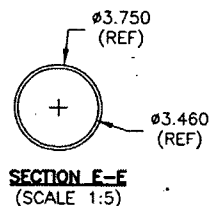
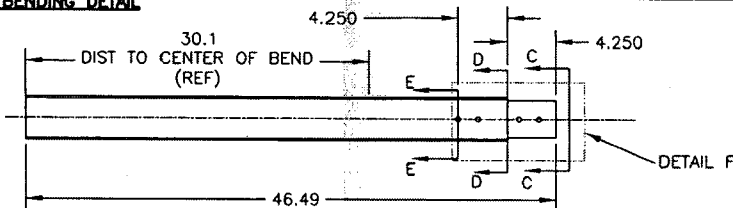
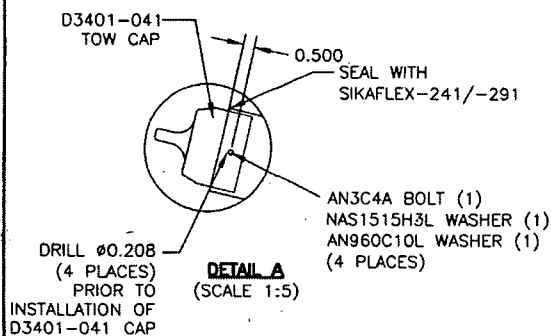
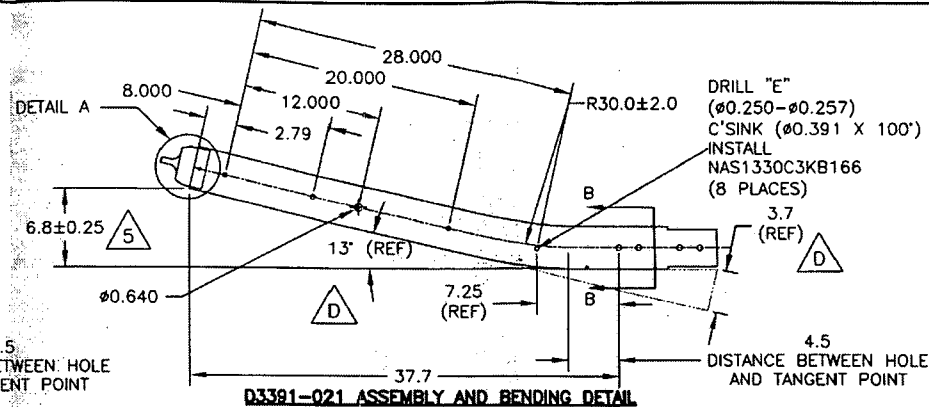
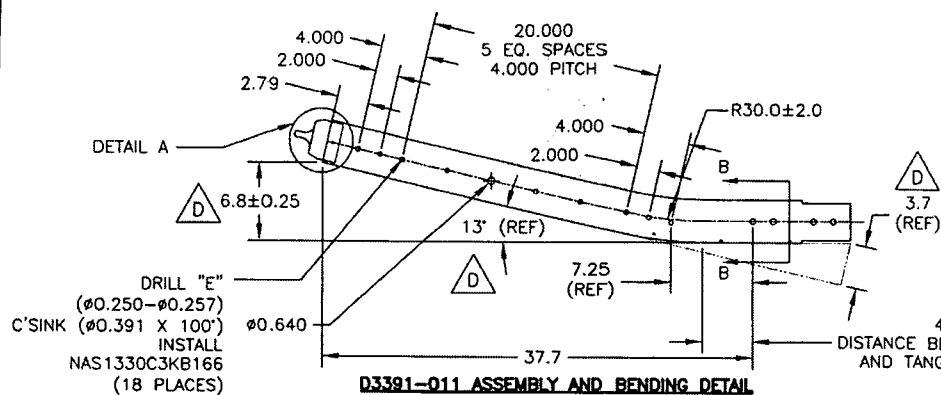
06-01-27

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DESIGN	D	06.01.23	UPDATE TOLERANCE, CHANGE HOLE SIZE
CHECKED	PH	05.09.27	LENGTHEN AFT EXTENSION
DATE	06.01.23	05.06.10	DRAWING UPDATES
	A	05.02.07	NEW ISSUE
DRAWN BY	PH		
APPROVED	#		
DRAWING NO.	D3391		
TITLE	412 FLOAT SKIDTUBE		
REV. D			
SHEET 1 OF 5			
SCALE			
NTS			

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WITHOUT NOTICE
WORK ORDER
NO. 26533



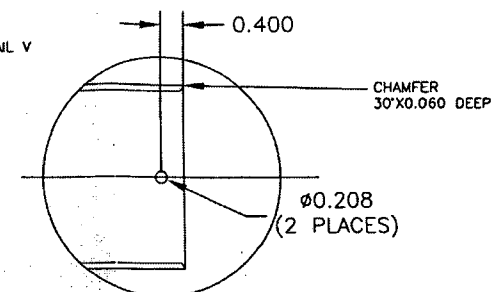
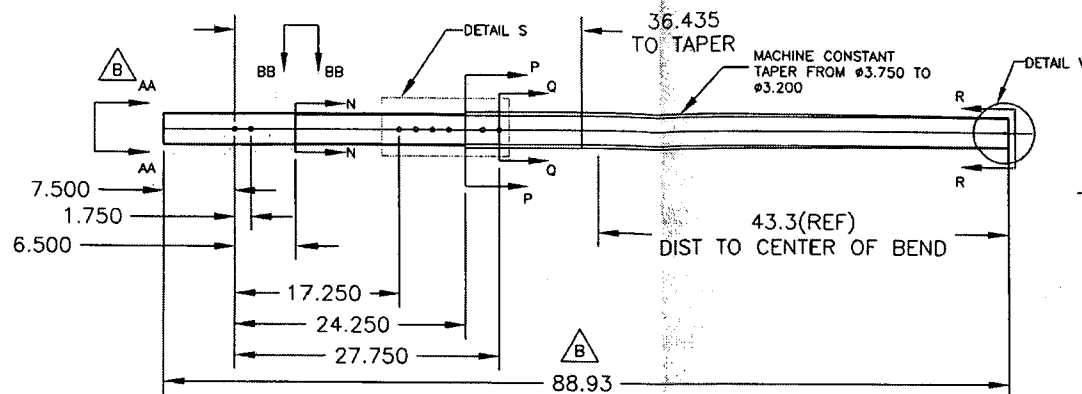
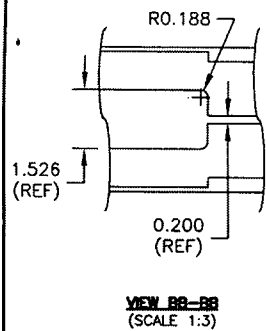
D3391-011/-021 FWD TUBE ASSEMBLY PARTS LIST

QTY - 011	QTY - 021	PART NUMBER	DESCRIPTION
X		D3391-011	FWD TUBE ASSEMBLY
	X	D3391-021	FWD TUBE ASSEMBLY
1	1	D6013-047	FWD TUBE
1	1	D3401-041	TOW CAP
4	4	AN3C4A	BOLT
4	4	NAS1515H3L	WASHER
4	4	AN960C10L	WASHER
24	14	NAS1330C3KB166	INSERT

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CHECKED	APPROVED	DATE	DRAWING NO.	REV. D	SHEET 2 OF 5
		06.01.23	D3391		
			TITLE	SCALE	1:10
			412 FLOAT SKIDTUBE		

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06.01.27

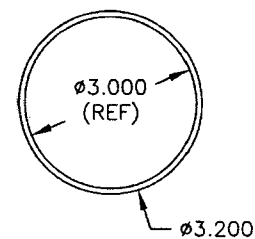
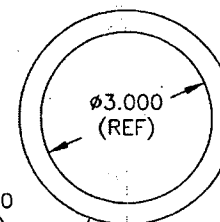
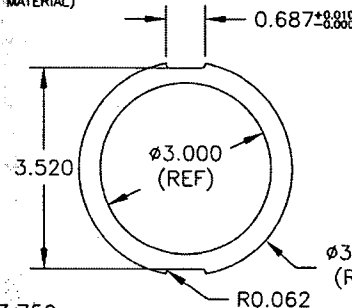
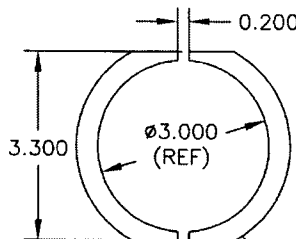
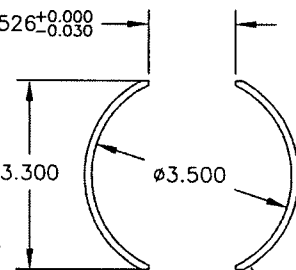


D3391-3 AFT DRILLING AND CUTTING DETAIL
(MAKE FROM D6014-090 SKIDTUBE MATERIAL)

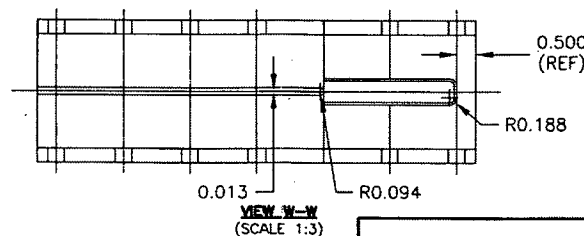
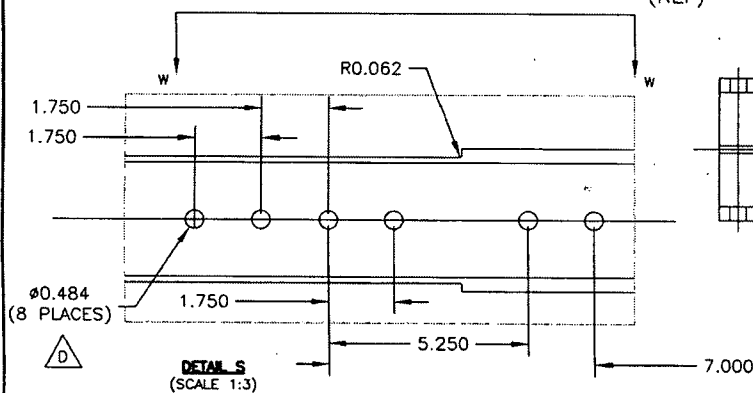
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DESIGN PH	DRAWN BY PH	DART DART AEROSPACE USA, INC. PORT HADLOCK, MA	REV. D
CHECKED A	APPROVED A	DRAWING NO. D3391	SHEET 4 OF 5
DATE 06.01.23	TITLE 412 FLOAT SKIDTUBE	SCALE 1:12	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

[illegible]

Measured by:	MB / m	Audited by:	EP	Prototype Approval:	
Date:	06/04/07	Date:	06/05/10	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	

